

Technical Data Sheet

Self Etching 1K Primer is a ready to use one component metal etching primer. It provides excellent adhesion and protection against corrosion to bare metal, thereby eliminating the need for metal conditioning. It is recommended for use to treat bare metal or for application under primer surfacers.

SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Steel	✓	Galvanized Steel	✓	Aluminum	✓

MIXING



Mix Ratio: Ready to Spray
Pot Life: Up to 5 days @ 70°C and 50% R.H.

SURFACE PREPARATION



First, degrease all surfaces with Transtar's SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394
Steel & Galvanized: Sand with 80-120 grit sandpaper. Degrease with Aqua SCAT 2 again before priming.
Aluminum and Fiberglass: Sand with 150-180 grit sandpaper. Degrease with Aqua SCAT 2 again before priming.
Previously Painted Surfaces: Sand and featheredge any surface repairs using 180 - 220 grit sandpaper.

SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.4 - 1.6 mm	1.2 - 1.6 mm
Air Pressure	10 PSI @ aircap	30-40 PSI @ gun
Mil Thickness: 0.3 mils per coat (dry film thickness)		

APPLICATION



AEROSOL:

Shake can vigorously for 1 minute to ensure color uniformity and to prevent clogging. Clean/degrease surfaces thoroughly using Transtar SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Apply 2 - 3 medium wet coats allowing a 3 - 5 minute flash time between coats. Spray with steady even strokes. Primer is dry to touch in 15 minutes. Allow one hour dry time before sanding, priming or topcoating. Sanding is not necessary if recoated within 24 hours.



QUART:

Stir primer thoroughly before use. For best results, apply 2 - 3 light coats. Allow to flash 5 minutes between coats. Dried film thickness is approximately 0.3 mils per coat. Recommended spraying viscosity is 14 - 17 seconds using a Zahn #2 cup. Reduction is not necessary. Primer is dry to touch in 15 minutes. Allow one hour dry time before sanding, priming or topcoating. Sanding is not necessary if recoated within 24 hours.

Note: 1K Self Etching Primer can be force dried at 140°F (60°C) for up to 30 minutes after air drying 5 minutes.

PRODUCT SPECIFICATIONS

Color: Olive Green (6183/6184), Gray (6193)	Shelf Life: 1 year
Size: 20 oz Aero (6183), Quart (6184), 20 oz Aero (6193)	Sprayable Viscosity: 14-17 seconds (Zahn #2 Cup)
% Solids: 18% RTU	Note: Do not store in a metal gun. Clean equipment immediately.

LIMITATIONS & PRECAUTIONS

- This product provides adhesion & corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded & applied.
- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- All Standard Operating Procedures (SOP) can be found on the Transtar website at www.tat-co.com.

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TINTING & ADDITIVES

Additives: Fisheye Remover (6737) - DO NOT USE.
 Universal Urethane Flex Additive (9194) - DO NOT USE.
 Kicker (6417): DO NOT USE.

REGULATORY

Category: Pre-treatment Wash Primer	6184	Category: ABP	6183/6193
		MIR	<0.95
VOC Actual	5.51#/gal (661 g/l)		
VOC Regulatory	6.42#/gal (769 g/l)		
Weight % of Volatiles	81.39		
Weight % of Water	0.1		
Weight % of Exempt Compounds	11.68		
Volume % of Exempt Compounds	14		
Density of Material #/gal	7.93		